

Work Order ID 92272

92272

Page 1

Item ID: D3391-013

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-10-24 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3391

1

100

0.00

100

Skidtubes

Skidtubes

Memo

1 Cut tube to finish length as per Dwg D3391

2 Identify as D3391-013

3 Drill pilot holes using DT8796 (including "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4 Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5 Remove .030" from Fwd indexing Ridge as per Dwg D3391

6 Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7 Deburr

8 Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9 Open wearplate holes of D3391-013 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10 Open wearplate holes of D3391-013 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

SCRAP

CF 12-10-25

Work Order ID 92272

92272

Page 2

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Item ID: D3391-013

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

~~11~~ Open .375" holes to .438" ***do not open fwd saddle holes***

~~12~~ Locate electric step holes at 39.6875" from fwd end and drill using DT 9612

~~13~~ Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

~~14~~ Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-013/-011 to 0.438" dia. in D3391-011

~~15~~ Transfer drill 2 wearplate holes into D3391-011 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-011.

~~16~~ Locating from two fwd wearplate holes drill remaining 6 wearplte holes in D3391-011 using DT8937

~~17~~ Open 2 fwd wearplate holes in D3391-013 to .250" dia.

~~18~~ counterbore two aft wearplate holes in D3391-011 as per dwg

19- Open ~~12~~ wearplate holes in D3391-011 to 0.297" dia.

20- insert D3391-011 into D3391-13

21- insert T-pins into first and third fwd saddle holes

23- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per

24- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".

CF 12.10.25

Work Order ID 92272

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92272

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Item ID: D3391-013

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

25- Deburr and blow out all chips from inside tube

→

CF

12-10-25

110

QC3- Inspect part completeness to step on W/O

0.00

DAS
16
3-5

11/10/25

110

QC

Quality Control

Memo

120-

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Hand Finishing

Memo

1 + f all 11/10/25

130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Quality Control

Memo

(1) SAD
12-30-25

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Item ID: D3391-013

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

Skidtubes

0.00

Skidtubes

Memo

1- Open holes to finish size as per dwg.

2- Prepare for welding

3- Bond web in place as per Dwg D3391 & QSI 015.

*****Ensure Web Aligment *****

A/R Sikaflex Batch: _____

Exp. date: _____

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

Photo
→
Laser

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA *[Signature]* Date: 13/02/25QA Closed: *CK* Date: 11

Work Order: <u>92272</u> Part No. <u>D3391-013</u> NCR No. <u>12-1093</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input checked="" type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
---	--	--	--	--	--	--	--	--	--	--	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	12/14/29	100	1	Several of the $\phi 0.313$ float holes were opened to $\phi 0.375$	<i>[Signature]</i>	SCRAP. High stress area, very little margin to play with.	<i>[Signature]</i> 12-10-30	<i>[Signature]</i> 12-10-30	DAS 16 2-82 12/10/30

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			

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Page 5

Item ID: D3391-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

Skidtubes

Memo

0.00

1-Weld crossbolt spacer as per dwg D3391 & QSI 004
A/R ALUM Batch: _____

2-grind weld flush

3- Transfer drill electric step pilot holes only from D3391-013 into D3391-015

4- Open electric step holes 0.391" per dwg D3391 (section L-L)

5- Open electric step holes 0.297" per dwg D3391 (section M-M)

6- Open electric step holes 0.250" per dwg D3391 (section LL-LL)

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

Work Order ID 92272***92272***

Page 6

Item ID: D3391-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Mid Tube Assembly

Stop ***NS2***

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

185

Pressure Wash per QSI005 4.3

0.00

185

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

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92272

Page 7

Item ID: D3391-013

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

230

HandFinishing

0.00

230

HandFinish

Memo

0.00

Hand Finishing

1- press fit D3591-1 spacers using DT9416 starting from 0.500" side

2- Install inserts

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

Inspect thread of each insert using DT8821

92272

Page 8

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/10/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 07/11/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Insp. Stamp

0.00

250

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

Assemble as per dwg D3391

QC5- Inspect part completeness to step on W/O

0.00

260

Memo

0.00

QC

Quality Control

Identify as per dwg & Stock Location:

0.00

270

Memo

0.00

Packaging

Packaging

Work Order ID 92272

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92272

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Item ID: D3391-013

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mid Tube Assembly

Start Date: 24/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

10/24/12-10-31

Picklist Print

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Page 1

Work Order ID: 92272

92272

Parent Item: D3391-013

D3391-013

Parent Item Name: Mid Tube Assembly

Start Date: 24/10/2012

Required Date: 07/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.12.13New IssueEC
 IPP B06.02.09Dwg rev.D EC
 IPP Rev:06-03-28 Update Manufacturing Instructions JLMIPP rev D
 07.03.14 dwg Rev F EC
 IPP Rev:E ECN 1056 07-11-13 DD verified by: EC
 IPP Rev:F 08-07-28 chg 0.332" to 0.391" dim. hole in comment DD verified
 by:EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP rev J
 10.03.30 revised process, added D3391-015 to pick list EC verified : DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332 R	Purchased	No				Each	21.0000		4			

*AN960C10L *

washer

**

Location	Loc Qty	Loc Code
ST	21	
107534	21	

D3389-1

Manufactured No

Each 8.0000

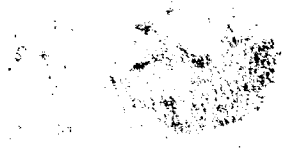
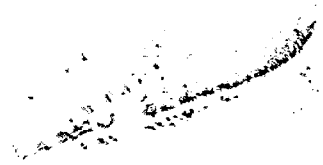
1

D3389-1

Web

**

Location	Loc Qty	Loc Code
LG	8	
85508	4	
86687	4	



Picklist Print

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Page 2

Work Order ID: 92272

Parent Item: D3391-013

Parent Item Name: Mid Tube Assembly

92272

D3391-013

Start Date: 24/10/2012

Required Date: 07/11/2012

Start Qty: 1.00

Required Qty: 1.00

D2500-1-100

Manufactured No

100

Each

158.0000

1

1

D2500-1-100

Skidtube Extrusion

**

CF 12-10-24

Location

Loc Qty

Loc Code

HALL

158

50251

3

82373

57

86065

98

Purchased

No

100

Each

138.0000

4

4

**

MS27039C4-08

MS27039C4-08

SCREW

Location

Loc Qty

Loc Code

310

50

122452

50

ST310

88

122141

88

Manufactured

No

140

Each

0.0000

1

**

CF 12-10-25

D3391-011

D3391-011

Fwd Tube Assembly

D3391-015

Manufactured

No

160

Each

0.0000

1

1

**

D3391-015

Aft Tube Assembly

Picklist Print

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Page 3

Work Order ID: 92272

Parent Item: D3391-013

Parent Item Name: Mid Tube Assembly

92272

D3391-013

Start Date: 24/10/2012

Required Date: 07/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3681-1

Manufactured No

160

Each

104.0000

12

12

D3681-1

Spacer

Location

Loc Qty

Loc Code

LG

94

80361

1

87611

93

LG001

10

68958

2

69893

2

71845

2

74874

1

76004

1

77501

2

ALS4-428-165

Purchased No

230

Each

409.0000

4

4

AIS4-428-165

Inserts

Location

Loc Qty

Loc Code

FP002

409

114172

18

117769

391

D3591-1

Manufactured No

230

Each

43.0000

2

2

D3591-1

Bushing

Location

Loc Qty

Loc Code

FP

5

80377

4

82027

1

ST059

38

57350

1

83237

37

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Shop Packet Print

Page 3

Picklist Print

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Work Order ID: 92272

Parent Item: D3391-013

Parent Item Name: Mid Tube Assembly

92272

D3391-013

Start Date: 24/10/2012

Required Date: 07/11/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

2,916.000

26

26

AI S4-1032-130

Insert

Location

Loc Qty

Loc Code

279

2527

122763

2527

ST280

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

140

121269

140

AN960C416L

NAS1149C0432
R

Purchased

No

250

Each

0.0000

4

4

***AN960C416I ***

WASHER

D3672-1

Manufactured

No

250

Each

1,361.000

4

4

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

FG

6

85222

6

FP001

2

80369

2

ST061

1353

72229

4

76277

21

83608

500

85222

348

91325

480

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Shop Packet Print

Page 4

Picklist Print

October-24-12 1:55:13 PM

Page 5

Work Order ID: 92272

Parent Item: D3391-013

Parent Item Name: Mid Tube Assembly

92272

D3391-013

Start Date: 24/10/2012

Required Date: 07/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

250

Each

1,153.000

4

4

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

FG

8

84432

8

ST061

1145

84432

33

86517

102

88441

500

89273

510

MS27039C1-09

Purchased

No

250

Each

104.0000

4

4

MS27039C1-09

SCREW

Location

Loc Qty

Loc Code

FP002

12

17831

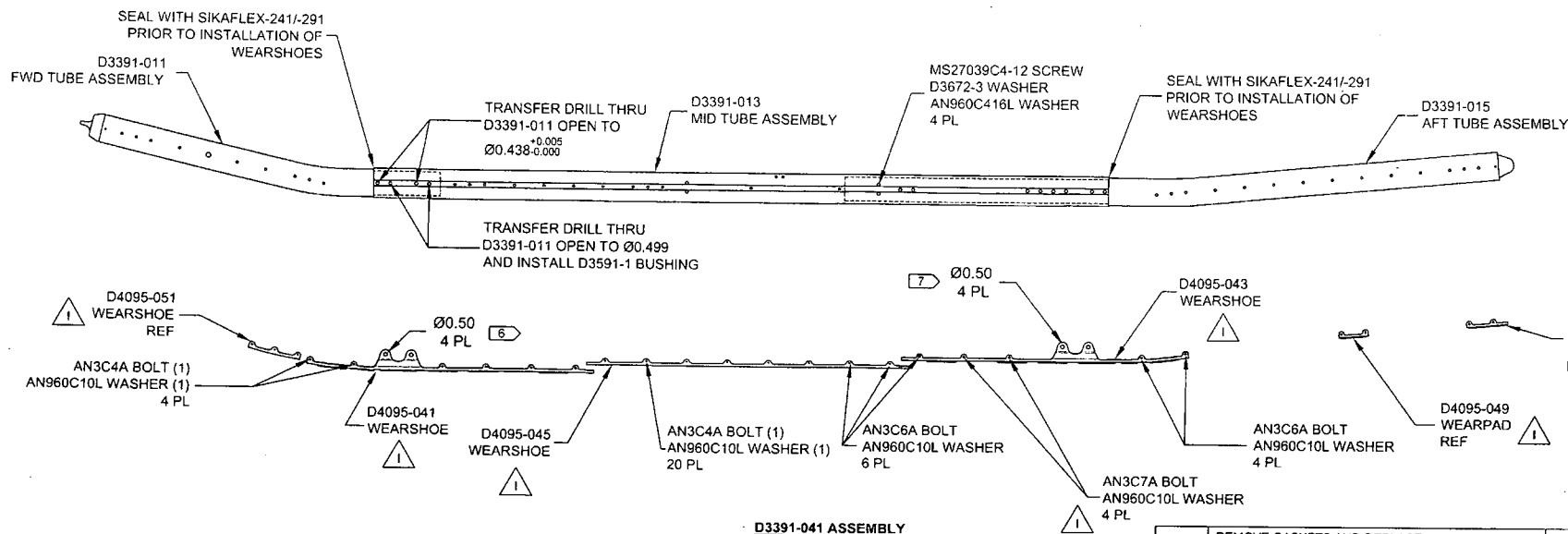
12

ST293

92

116290

92



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

SHOE COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

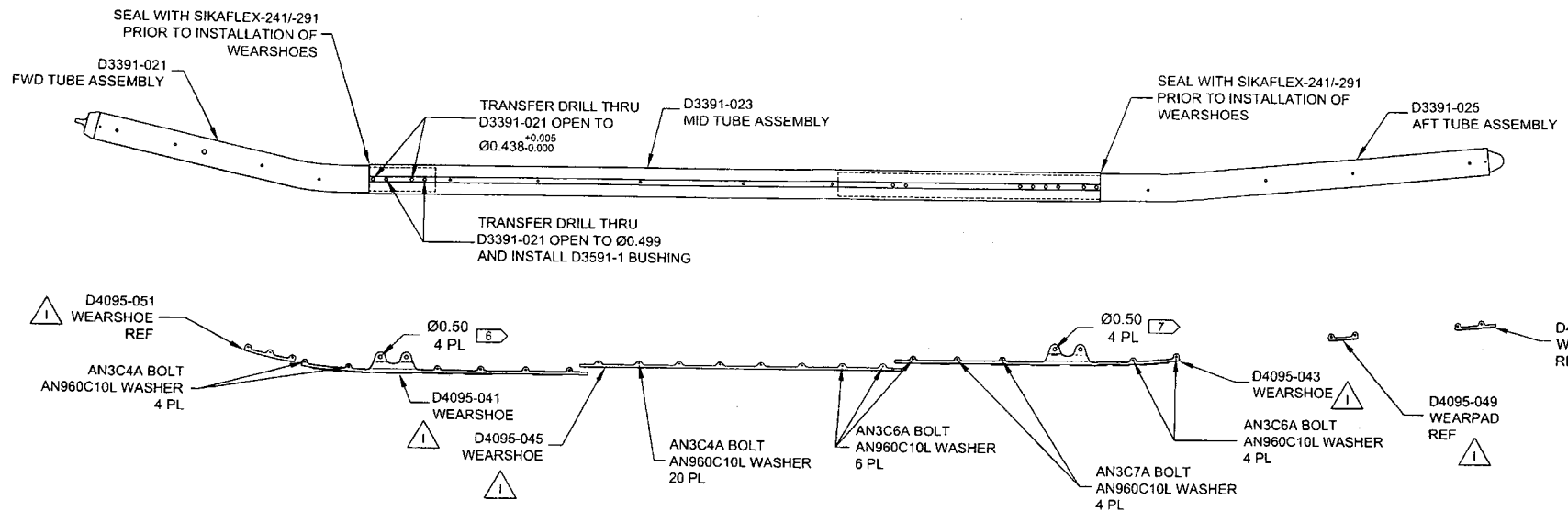
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
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CHECKED		DRAWING NO.	REV. I
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92272



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

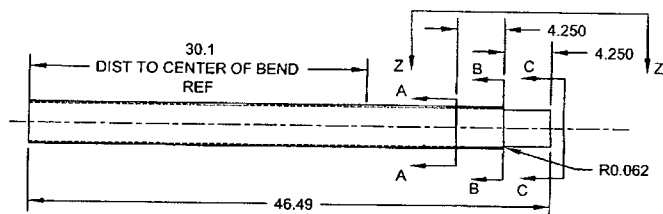
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

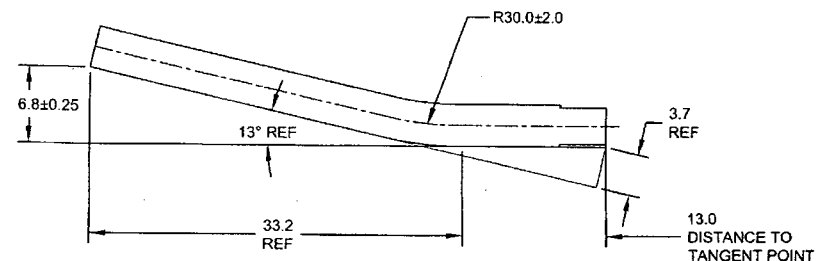
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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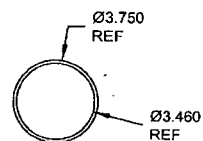
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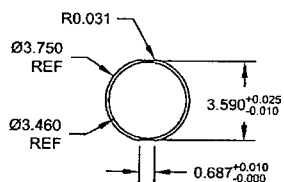
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



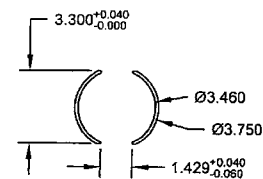
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



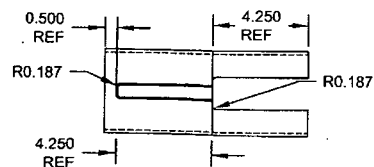
SECTION A-A
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SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

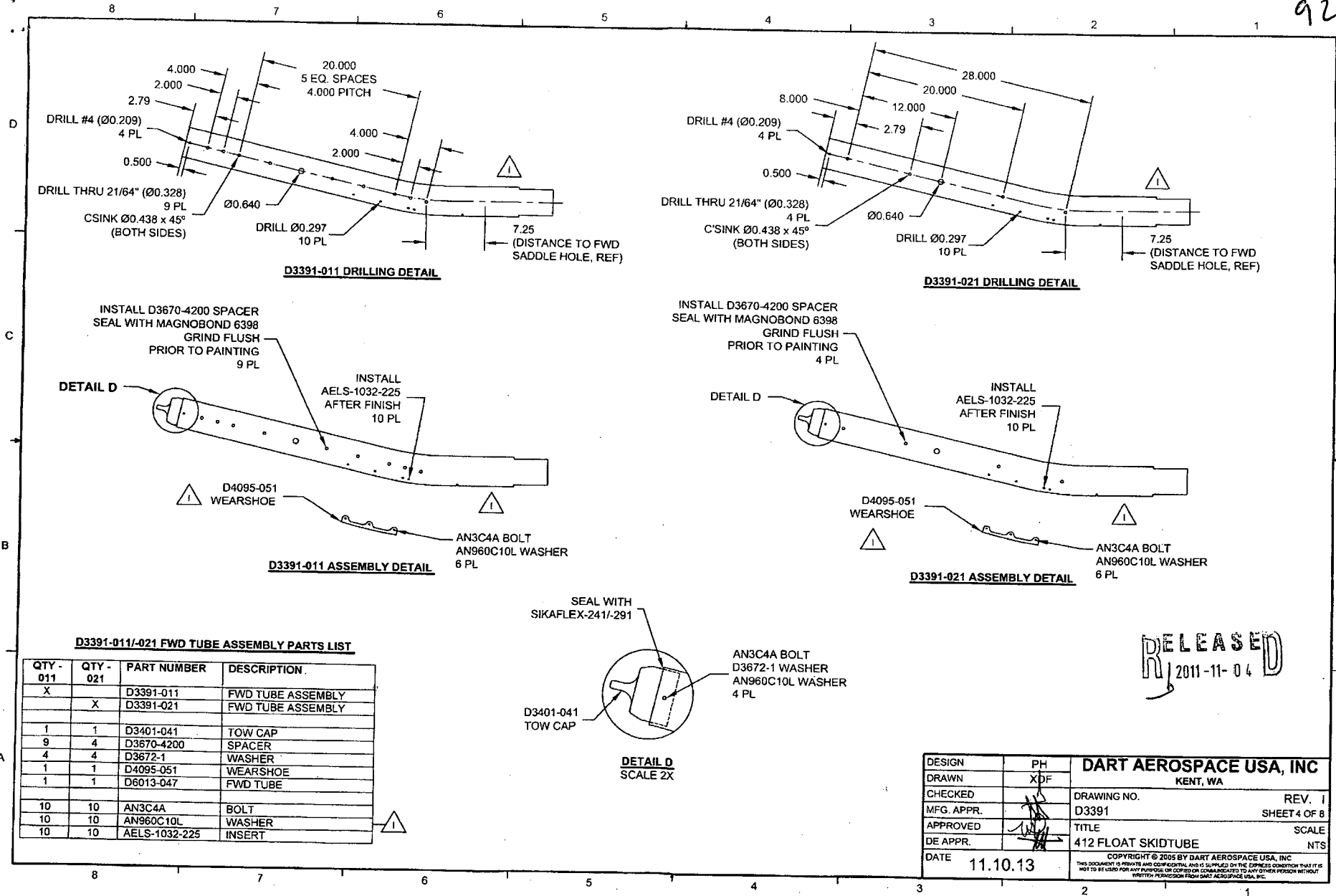


VIEW Z-Z
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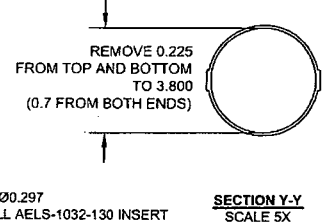
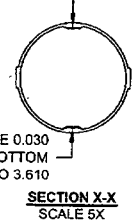
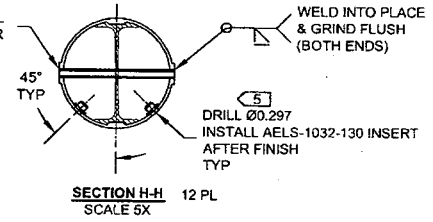
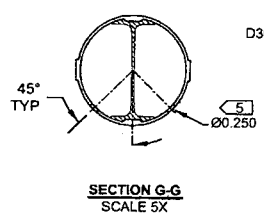
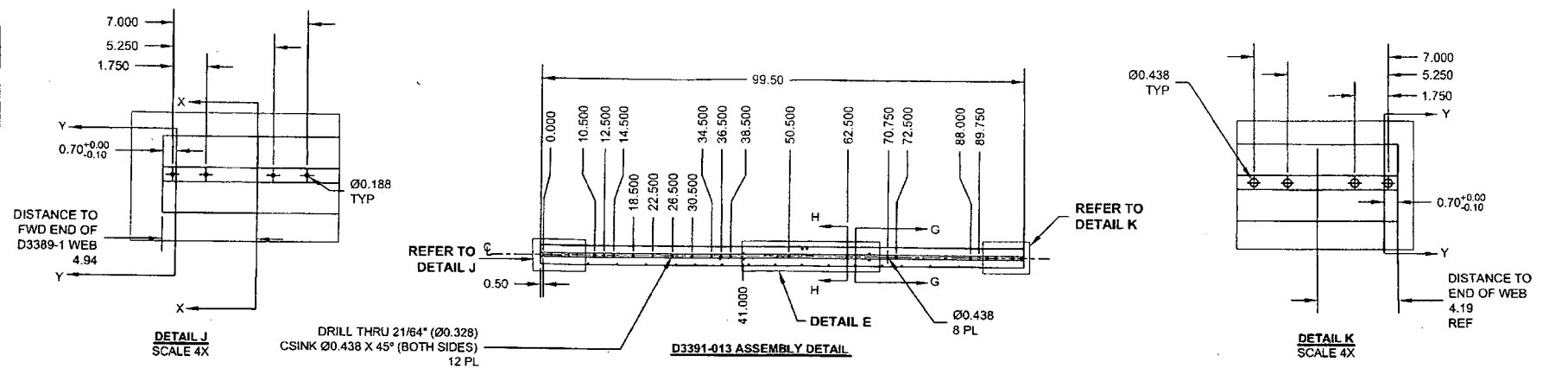
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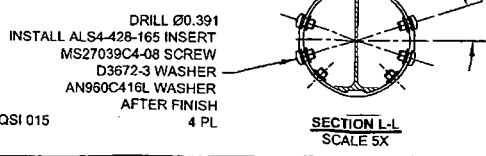
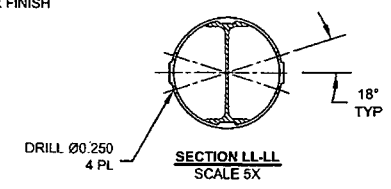
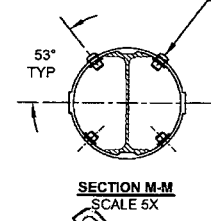
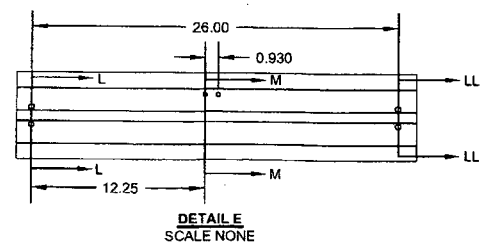


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D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3581-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



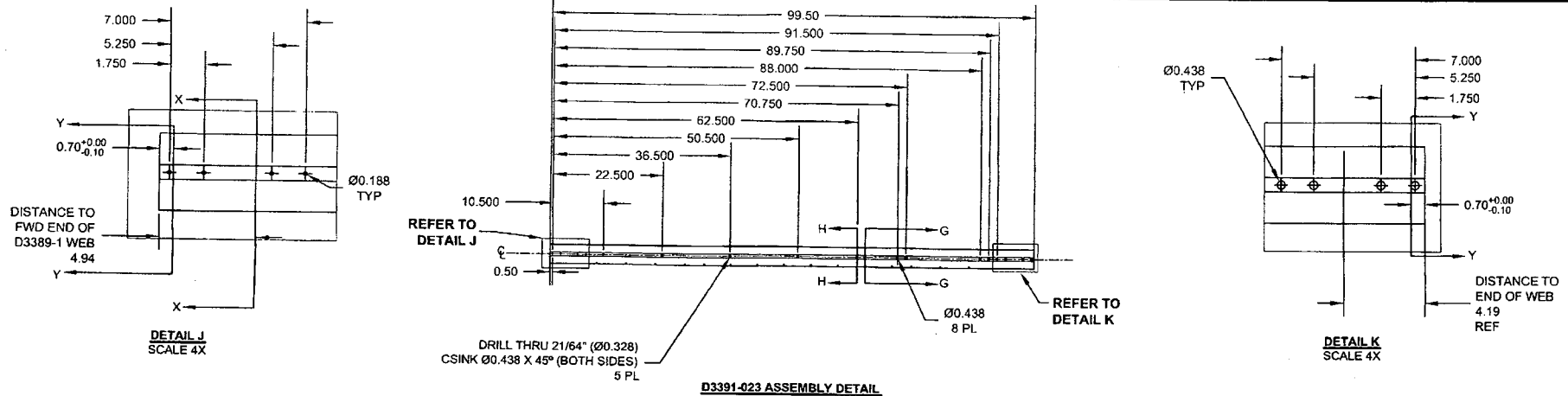
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

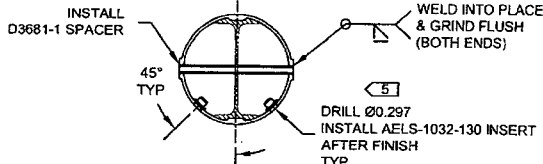
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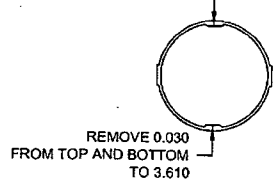
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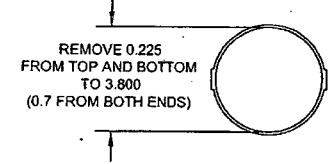
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

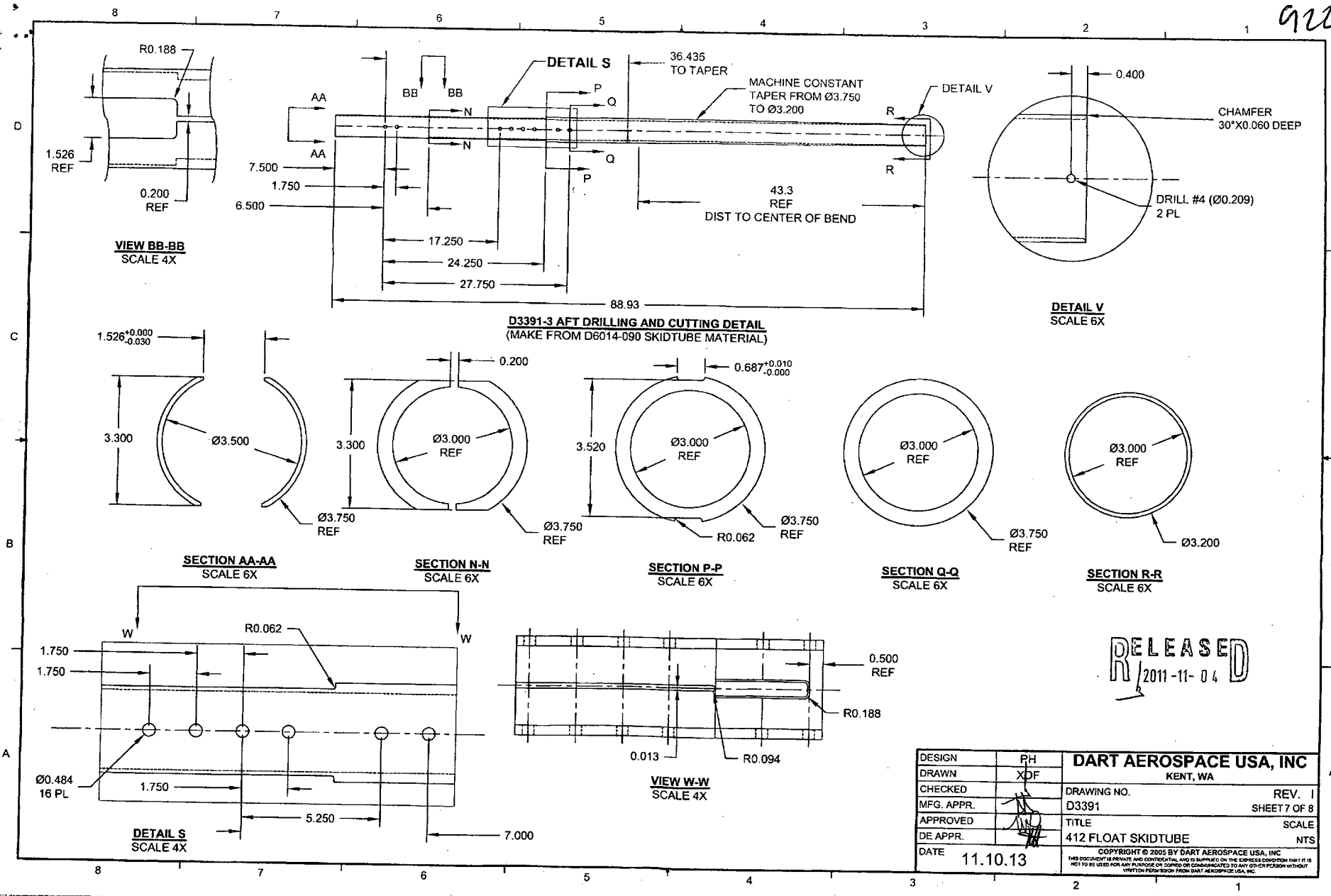
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

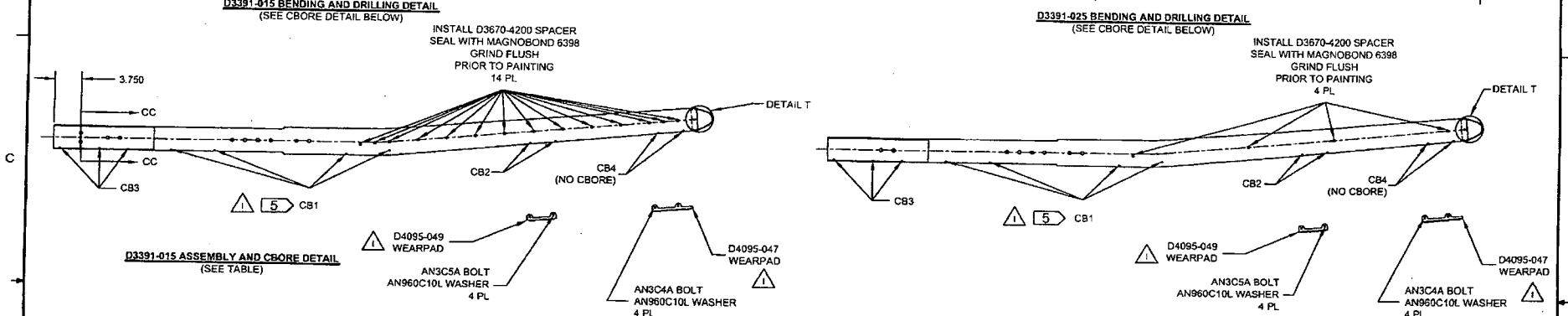
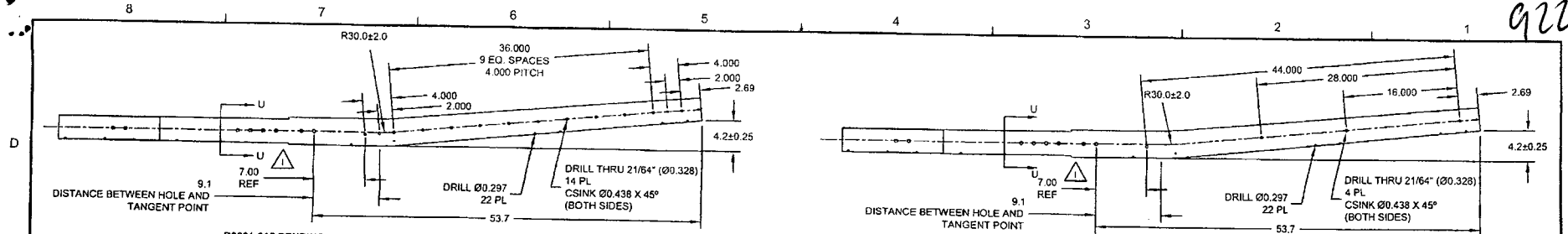
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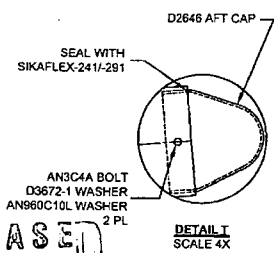
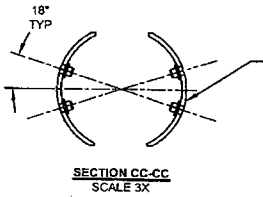
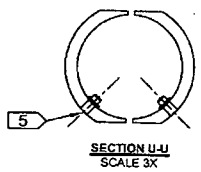


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D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



RELEASED
2011-11-04

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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